

Date Opened: 16 January 2013

Job #: 945
Project: Wide Basket
Type: Bell 206L/407Approval: SH00-48
Drawing List: DCL945-10, Rev. 0

Fabrication and Assembly Drawing(s)	Description
94510, Rev. 0	Basket Ass'y
94511, Rev. 0	Basket Body Ass'y
69812, Rev. 3	Basket Lid Ass'y
94520, Rev. 0	Hoop
94521, Rev. 0	Forward Hoop
94522, Rev. 0	Aft Hoop
84255, Rev. 1	Handle Installation
84261, Rev. 1	Handle Bar Ass'y
84262, Rev. 1	Handle Bracket Ass'y
70405, Rev. 3	Lid Step Modification
70411, Rev. 0	Front End Cutout Modification

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record: Y
Document Control List revision level matches (or exceeds) STC: Y
Drawings revision levels match Document Control List: Y

Purchase order or Work order source is recorded for each part/ass'y: Y
Tests and inspections specifically called out on drawings are complete: Y
Release tags associated with all fabricated parts are attached: Y
All mounting hardware and supplies are included: Y

List all non-conformities raised: _____

Welder Signature: _____

Date: _____


Inspector Signature: _____10 Dec 13
Date: _____

Drawing: **94510** Revision **0**
 Assembly: **94510-01** **Cargo Basket Ass'y (Quick-Release)**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5/8 Total	94510-01	Cargo Basket Assembly			
. 1	94511-01	Basket Body Assembly	Below		
. 1	69812-01	Basket Lid Assembly	Below		
. 1	84255-01	Handle Bar Installation	Below		
. 1	36280-01	Brace Assembly	9-2081 Brace		
. 1	MS20001P4	Piano Hinge			
. 1	69827-01	Placard	0.050" Sheet, 6061-T6 Aluminum		
. 3	49205-14	Bumper	Argus Industries Bumper		
. A/R	CR3213-5-02	Blind Rivet			
. 8	CR3523-5-02	Monel Blind Rivet			
. 4	CR3213-4-02	Blind Rivet			
. 4	40088-14	Fitting	Ancra		
. 4	AN960-616	Washer			
. 1	AN3-15A	Bolt			
. 1	AN3-17A	Bolt			
. 4	AN960-10	Washer			
. 2	AN970-3	Washer			
. 2	MS21044N3	Nut			

Processes	Per	Mat'ls Used	Inspection	Signature
Riveting	AC43.13-1B	CR3213-5-02, CR3523-5-02 Rivets, CR3213-4-02		
Final Inspection	Drawing 94510			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: **94511** **Revision 0**
 Assembly: **94511-01** **Basket Body Ass'y (Quick-Release)**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5/8 Total	94511-01	Basket Body Assembly			
. A/R	--	Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube		
. A/R	--	Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube		
. 3	94520-01	Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube		
. 1	94521-01	Forward Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube		
. 1	94522-01	Aft Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube		
. 4	69823-02	Lug	1018 Mild Steel, 5/8" Rod		
. 1	84262-01	Handle Bracket Assembly	Below		
. 1	49215-01	Spacer	1018 Steel, 1/2" Rod		
. A/R	3/4-16F	Mesh	Expanded carbon steel		

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 94511	PO 12088 & 12090		
Final Inspection	Drawing 94511			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: **69812** **Revision 3**
 Assembly: **69812-01** **Basket Lid Ass'y (Quick-Release)**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 8 Total	69812-01	Basket Lid Assembly			
. 2	69824-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube		
. 2	49212-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube		
. 3	49213-01	Lid Brace	4130 Steel, 3/4" x 0.035 Sqr. Tube		
. 1	49216-01	Spacer	1018 Steel, 1/2" Rod		
. 1	84262-01	Upper Handle Bracket Assembly	Below		
. 1	36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	WO 2012-20	
. A/R	3/4-16F	Mesh	Expanded carbon steel		

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 69812	PO 12088 & 12090		
Final Inspection	Drawing 69812			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 84255 Revision 1
Assembly: 84255-01 Handle Installation

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
3 Total	84255-01	Handle Installation			
. 1	84261-01	Handle Bar Assembly	Below		
. 2	84267-01	Bracket	Delrin, 3/4" Sheet		
. 2	36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire		
. 2	36275-01	Bushing	SAE 660 Bronze, 5/16" Dia		
. 2	AN3-12A	Bolt			
. 4	AN3-11A	Bolt			
. 12	AN960-10	Washer			
. 6	MS21044N3	Nut			

Processes	Per	Mat'ls Used	Inspection	Signature
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Final Inspection	Drawing 84255
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Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 84261 Revision 1
Assembly: 84261-01 Handle Bar Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
5 8 Total	36261-01	Handle Bar Assembly			
. 1	36277-01	Handle Bar	316 Stainless, 1.0 x 0.035 Rnd. Tube		
. 2	84265-01	Lever	304 Stainless, 0.105 Sheet		
. 2	36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube		
. 2	MS20615-4M3	Monel Rivet		7039	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84261			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 84262 Revision 1
Assembly: 84262-01 Handle Bracket Assembly

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
53 Total	84261-01	Handle Bracket Assembly			
. 4	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Tube		
. 4	36273-01	Lid Bracket	321 Stainless, 0.050 Sheet		
. 2	36275-02	Support	304 Stainless, 5/16" Rod		

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84262			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: **70405** **Revision 3**
Assembly: **70405-01** **Lid Step Modification**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
3 2 Total	70405-01	Lid Step Modification			
. A/R	70405-03	Tube	4130 Steel, ½ " x 0.035 Sqr. Tube		
. A/R	70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"		
. 18	CR3213-4-2	Cherry Rivet			

Note: Remainder of assembly listed on drawing 69812

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Final Inspection	Drawing 70405			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: **70411** **Revision 0**
Assembly: **70411-01** **Front End Cutout Modification**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
4/1 Total	70411-01	Front End Cutout Modification			
. 2	-	Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube		
. 1	3/4-16F	Mesh	Expanded carbon steel		


Note: Remainder of assembly listed on drawing 94611 and 94612

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ^{ER70S-2} ER308L		
Final Inspection	Drawing 70411			


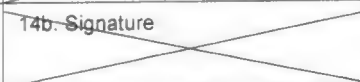

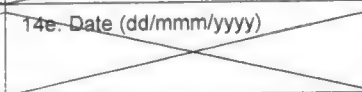
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Tag complete parts / assemblies with Release Tag prior to storage.

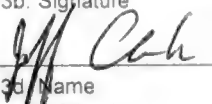
Fab +
Assy
4 Tags 8130

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 2013 39th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice WO 2013-07
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	Cargo Basket	94510-01	1	94501-04	New
12. Remarks Modified with front end cutout IAW DCL704					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke		13e. Date (dd/mmm/yyyy) 11 Feb 2013		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					


Valley

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 2013 39th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice WO 2013-07
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	Cargo Basket	94510-01	1	94501-06	New
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation <input type="checkbox"/> Non approved design data specified in block 12			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature		13c. Approved Organization Number		14b. Signature	
		AMF 73-04			
13d. Name		13e. Date (dd/mmm/yyyy)		14d. Name	
Jeff Clarke		13 May 2013			
14e. Date (dd/mmm/yyyy)					
					
Installer Responsibilities					
This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					

MADONNA

1. Approving Civil Aviation Authority/Country Transport Canada		2 AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 2013 39th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice WO 2013-07
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	Cargo Basket	94510-01	1	94501-05	New
12. Remarks Modified with lid walkway and front end cutout IAW DCL704					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke		13e. Date (dd/mmm/yyyy) 13 May 2013		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
Installer Responsibilities					
<p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

HELI TRANSPORT

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address AERO Design Ltd. – 2013 39th Avenue NE, Calgary, Alberta, T2E 6R7					5. Work Order/Contract/Invoice WO 2013-07	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	Cargo Basket	94510-01	1	94501-07	New	
12. Remarks Modified with front end cut-out and walkway on lid IAW DCL704.						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature 		13c. Approved Organization Number AMF 73-04		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke		13e. Date (dd/mmm/yyyy) 14 June 2014		14d. Name		14e. Date (dd/mmm/yyyy)
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

Avialata



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: BASKET BODY (407 XL) No. of pieces: 1

Manufacturer: AERO DESIGN

Part No.: 94510-01 Serial / Batch No.: U/K

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2013-07

Remaining Tasks to be Performed: ASSEMBLY U/LID

Signature: JH Chh.

Date: 01 AUG 2013 Lic. No. / ACA

In Process



Aero Design Ltd.

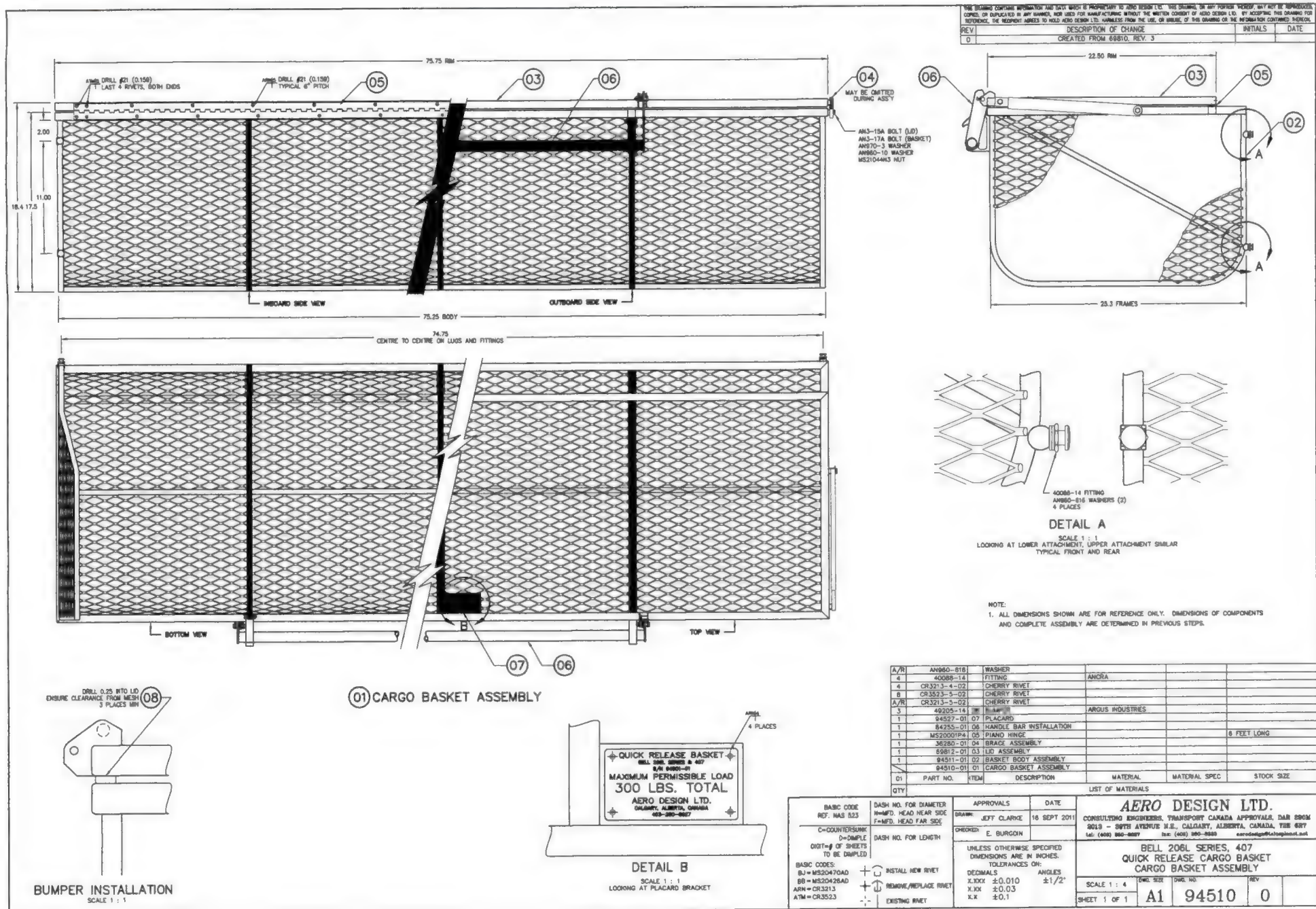
9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

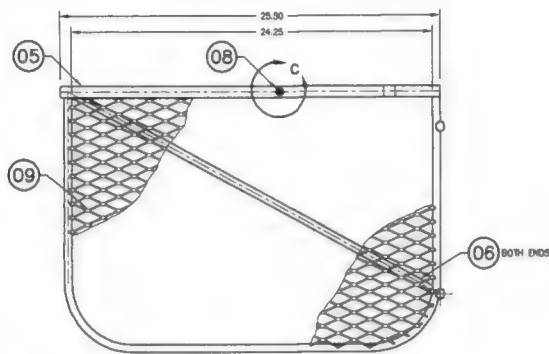
Remarks

In Process

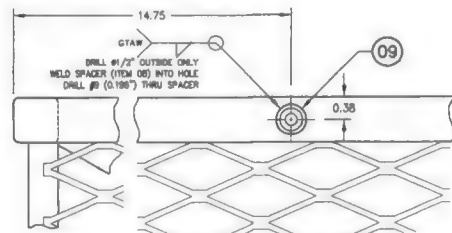


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REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	CREATED FROM 84811, REV. 3		

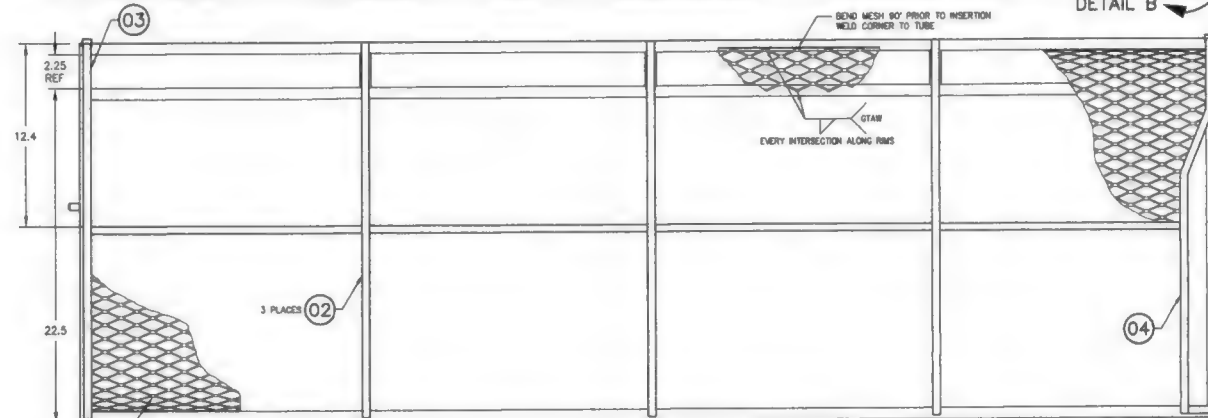
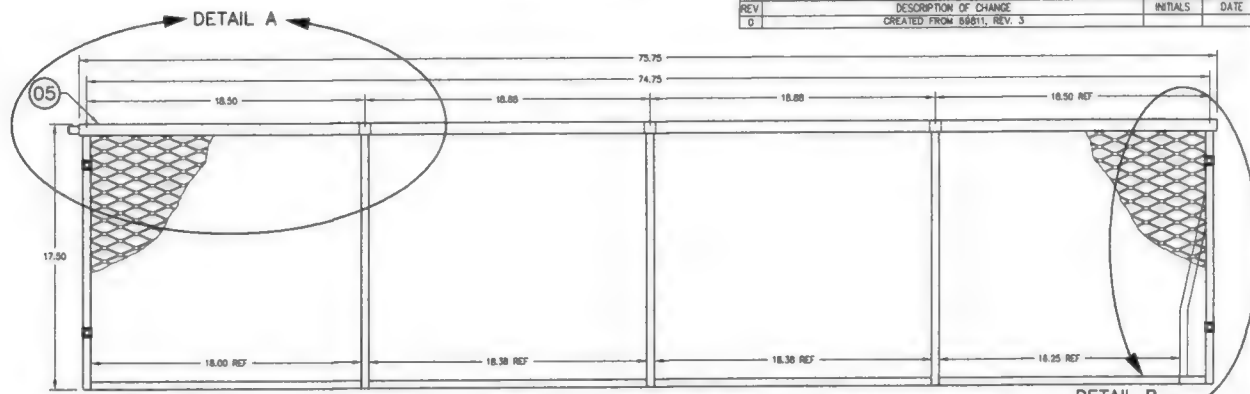
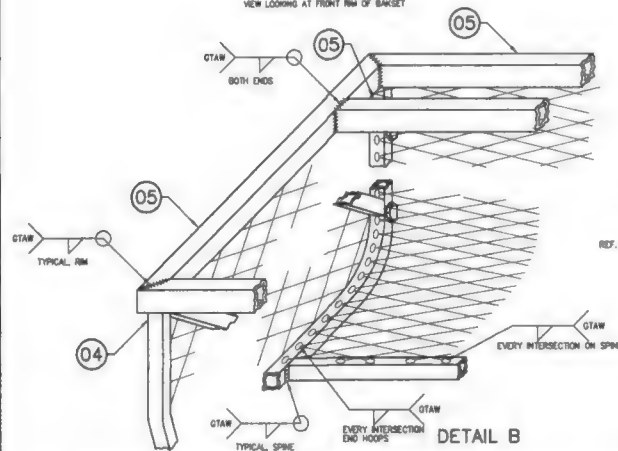


- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
 2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2880C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
 3. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
 4. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY.

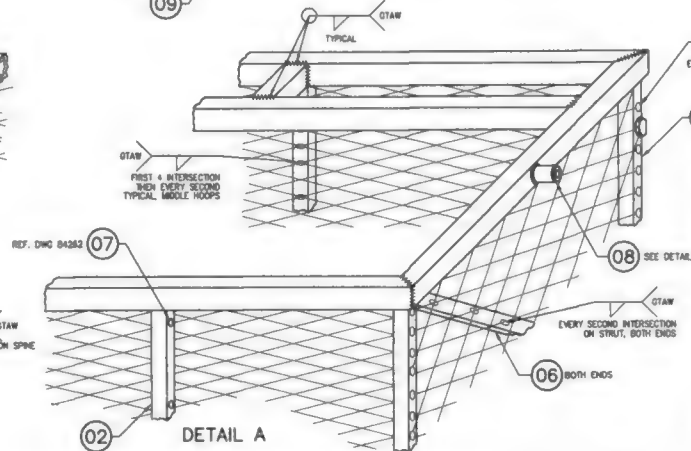


DETAIL C

SCALE 1:1
VIEW LOOKING AT FRONT RIM OF BASKET



01 BASKET BODY ASSEMBLY

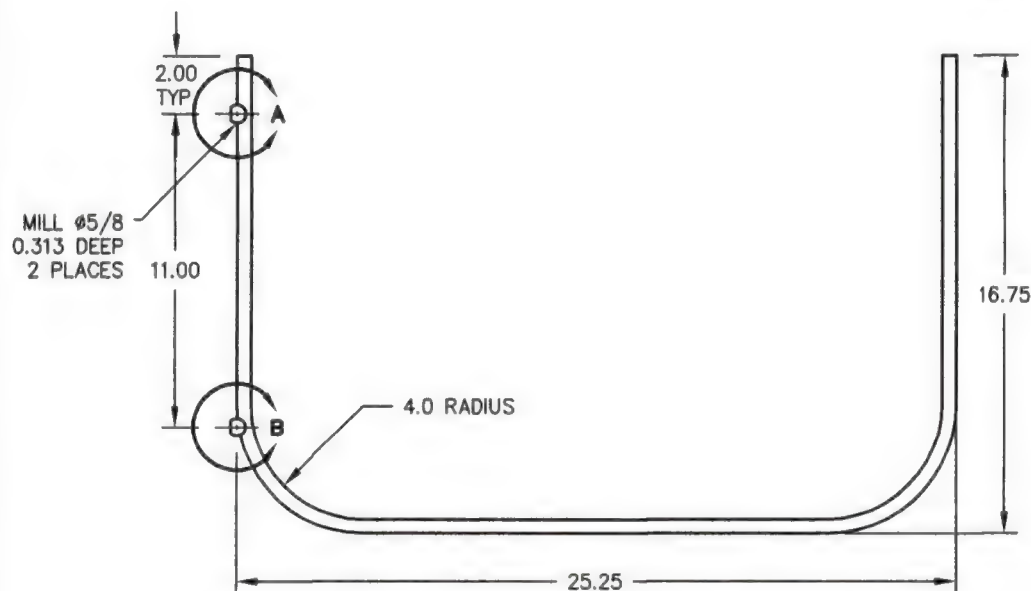


A/R	3/4-16F	08	MESH	STEEL	COMMERCIAL		
1	48215-01	08	SPACER				
1	84283-01	07	HANDLE BRACKET ASSEMBLY				
A/R	--	08	TUBE	4130 STEEL, COND. N	MIL-T-8738	0.5 X 0.035 SQ. TUBE	
A/R	--	05	TUBE	4130 STEEL, COND. N	MIL-T-8738	0.75 X 0.035 SQ. TUBE	
1	84522-01	04	AFT END HOOP				
1	84521-01	03	FORWARD END HOOP				
3	84520-01	02	HOOP				
1	84511-01	01	BASKET BODY ASSEMBLY				
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE	
QTY				LIST OF MATERIALS			

APPROVALS		DATE	
DRAWN: JEFF CLARKE		13 SEPT 2011	
CHECKED: E. BURGOIN			
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ON:			
DECIMALS		ANGLES	
X.XXX ±0.010		±1/2°	
X.XX ±0.03			
X.X ±0.1			

AERO DESIGN LTD.			
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 800M			
3015 - 50TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2B 6R7			
tel: (403) 880-8887		fax: (403) 880-8888 email: info@aerodesign.net	
BELL 206L SERIES, 407 QUICK RELEASE CARGO BASKET BASKET BODY ASSEMBLY			
SCALE 1:4	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A1	94511	0

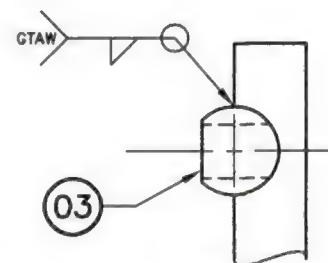
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0			



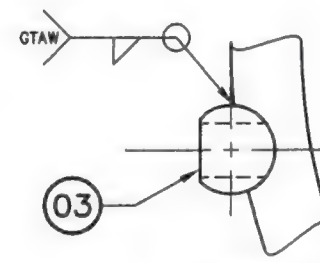
① FORWARD HOOP

NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.
2. DRILL 3/32" VENT HOLE IN BOTTOM OF HOOPS FOR VENTING WELD GASES.
3. WELDING OF LUGS TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.



DETAIL A
SCALE 1 : 1



DETAIL B
SCALE 1 : 1

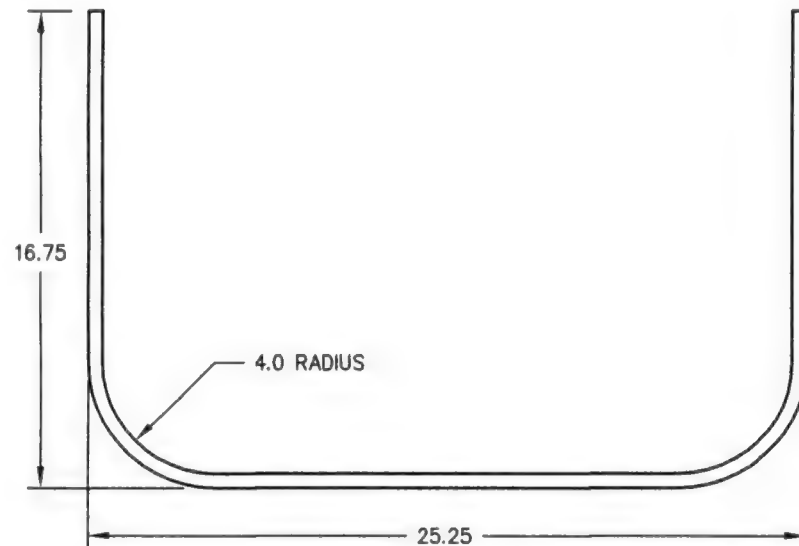
2	69823-02	02	LUG	1018 MILD STEEL	AIISI 1010/1020	5/8 ROD
	94521-01	01	FORWARD HOOP	4130 STEEL COND. N	MIL-T-6736	1/2 x 0.035 SQR. TUBE
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

LIST OF MATERIALS

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APPROVALS	DATE
DRAWN: JEFF CLARKE	13 SEPT 2011
CHECKED: E. BURGAIN	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:	
DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8087 fax: (403) 250-8333 www.aerodesign.ca			
BELL 206L SERIES, 407 QUICK RELEASE CARGO BASKET FORWARD HOOP			
SCALE 1 : 5	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	LGL	94521	0



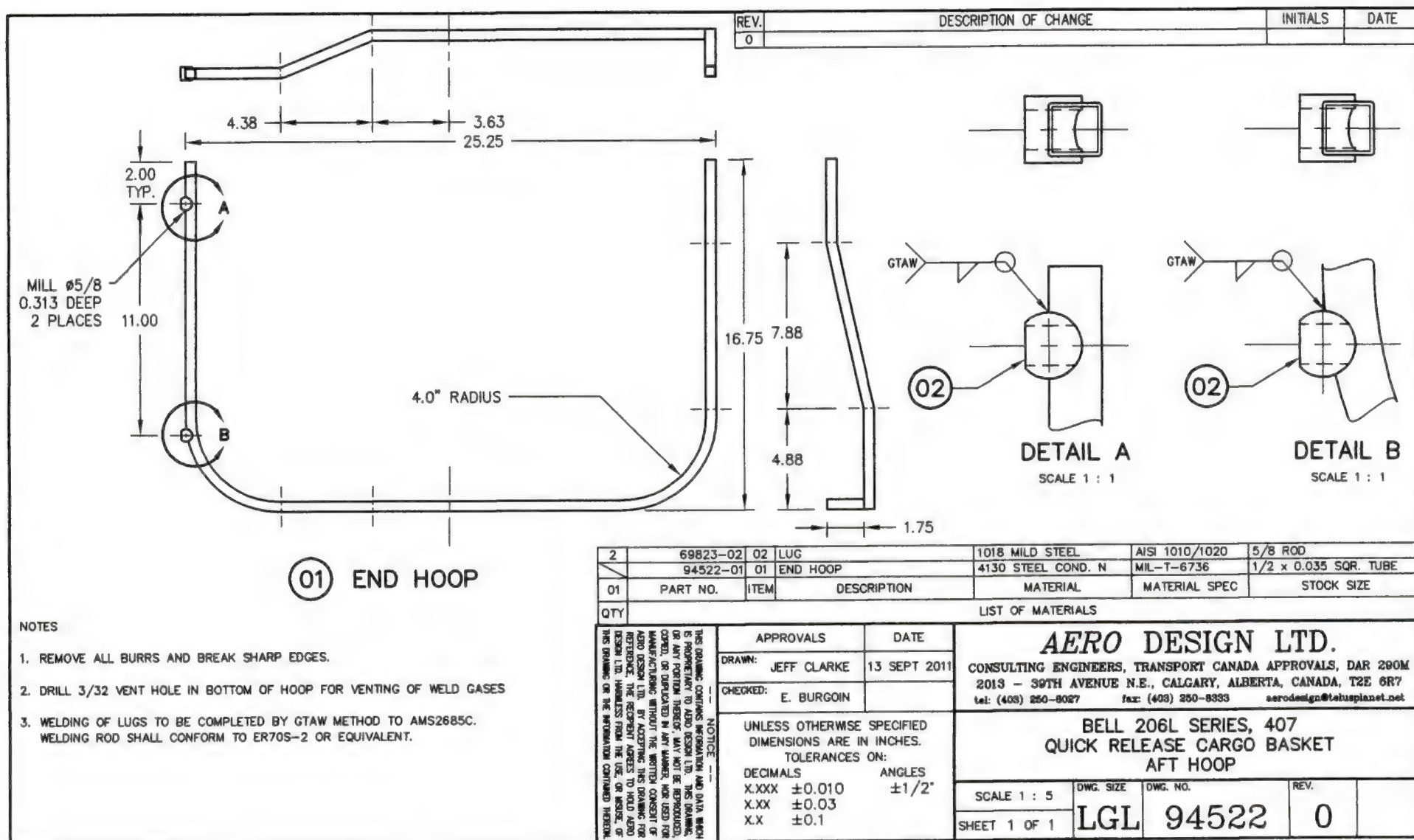
(01) HOOP

NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.
2. DRILL 3/32" VENT HOLE IN BOTTOM OF HOOPS FOR VENTING WELD GASES.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0			

	94520-01	01	END HOOP	4130 STEEL COND. N	MIL-T-6736	1/2 x 0.035 SQR. TUBE						
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE						
QTY	LIST OF MATERIALS											
<div>NOTICE</div> <div>THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING OR ANY PORTION THEREOF MAY NOT BE REPRODUCED, COPIED, OR OTHERWISE IN ANY MANNER NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.</div>							APPROVALS		DATE		<div>AERO DESIGN LTD.</div> <div>CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M</div> <div>2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7</div> <div>tel: (403) 260-8087 fax: (403) 260-8333 www.aerodesign.ca</div>	
							DRAWN: JEFF CLARKE		13 SEPT 2011			
							CHECKED: E. BURGAIN					
							UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1				BELL 206L SERIES, 407 QUICK RELEASE CARGO BASKET HOOP	
				SCALE 1 : 5		DWG. SIZE	DWG. NO.	REV.				
SHEET 1 OF 1				LGL		94520		0				



NOTICE

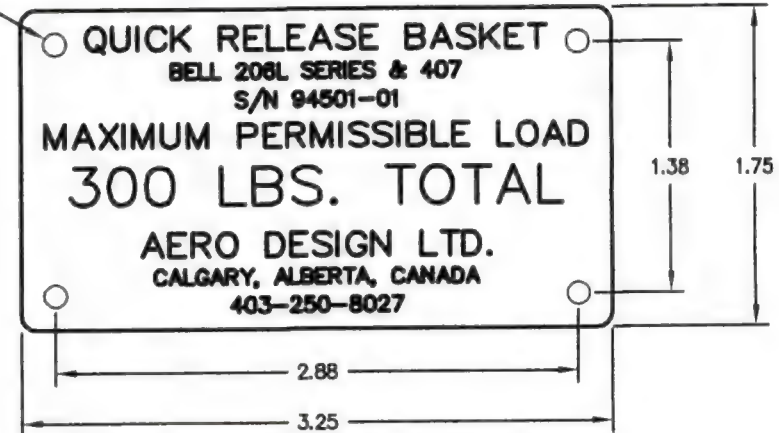
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	ORIGINAL ISSUE		


NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:
 "QUICK RELEASE BASKET" - 0.125 HIGH
 "BELL 206L SERIES & 407" - 0.080 HIGH
 "S/N 94501-XX" - 0.080 HIGH
 "MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
 "300 LBS. TOTAL" - 0.200 HIGH
 "AERO DESIGN LTD." - 0.125 HIGH
 "CALGARY, ALBERTA, CANADA" - 0.080 HIGH
 "403-250-8027" - 0.080 HIGH

DRILL #30 (0.129)
4 PLACES



01 PLACARD

1	94527-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
	APPROVALS		DATE	AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 aerodesign@telusplanet.net		
	DRAWN: JEFF CLARKE		16 SEPT 2011			
	CHECKED: E. BURGON					
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1			BELL 206L SERIES, 407 QUICK RELEASE CARGO BASKET PLACARD		
				SCALE 1 : 1	DWG. SIZE	DWG. NO.
			SHEET 1 OF 1	A1	94527	0

CARGO BASKET ASSEMBLY - COMMON

WO # 2013-07
~~WO 2013-48~~ ADOG

B206L/407 X-WIDE BASKET

General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69810, Revision 3 – Standard Low Mounted Basket

→ 94510, Revision 0 – Extra-Wide Low Mounted Basket

94610, Revision 0 – Extra-Wide Low Mounted Ski Basket

76610, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77610, Revision 1 – Short Basket

76410, Revision 3 – Medium Basket (left or right)

78410, Revision 2 – Long Basket

94010, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90610, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80210, Revision 0 – Short Basket

80310, Revision 0 – Medium Basket

81110, Revision 0 – Long Basket

Bell 429 – right or left

95911, Revision 0 – Standard Basket

Bell Medium – left or right

75111, Revision 0 – Standard Basket

95511, Revision 0 – Extra Large (ski) Basket

MD600

82811, Revision 0 – Standard Basket

Options

70405, Revision 3? – Lid Walkway

CARGO BASKET ASSEMBLY - COMMON

B206L/407 X-WIDE BASKET

Complete
(initial or SCA #)

Work Order: 2013-48

Date Open: _____

AD06

1. Lid Assembly

- a. Install lid bumpers on bottom.
 - i. Fill bumper holes with RTV silicone sealant.
 - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
 - i. Locate placard on bracket.
 - ii. Drill #30 through placard and bracket, using holes in placard.
 - iii. Remove placard and de-burr holes in placard and on bracket.
 - iv. Locate placard on bracket, and cleco in place.
 - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
 - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
 - ii. Pull tread plate from stock. Shear tread plate to length.
 - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
 - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
 - v. Mark and drill #30 holes:
 1. 0.25" from edge of tread plate, centre on cross members (0.38")
 2. 0.25" from edge of tread plate, middle of each walkway stringer
 - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
 - vii. De-burr holes in lid tubes.
 - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
 - ix. Set tread plate in place, secure with clecos if necessary.
 - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

2. Body Assembly

AD06

- a. Install attachment fittings
 - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
 - ii. Run 3/8-24 tap into attachment lugs to clear threads.
 - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
 - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
 1. 90610 (Robinson R44) basket only:
 - a. Install 1 fitting 906?? in lower forward attachment lug only.
 - b. Install 3 96710-01 fittings in remaining locations.
 - v. Torque to ??

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
 - i. Locate 94621-01 Brace over aft cross tube cutout
 - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
 - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

3. Hinge Installation

ADD

- a. Prepare hinge.
 - i. Cut hinge to length:
 - 1. 776, 906 – 54"
 - 2. 751, 803 – 70"
 - 3. 698, 764, 945 – 72"
 - 4. 784 – 90"
 - 5. 940, 946, 959 – 95"
 - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
 - i. Locate hinge on basket (standard baskets)
 - 1. centre fore/aft
 - 2. 0.15" – 0.18" up from bottom edge
 - ii. Locate hinge on basket (extra wide baskets)
 - 1. centre fore/aft
 - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
 - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
 - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
 - v. Remove hinge and de-burr holes in hinge and basket rim.
 - vi. Cleco hinge to basket with 5/32 clecos.
 - vii. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
 - i. Locate lid on hinge (all baskets)
 - 1. center fore/aft
 - 2. 0.15" – 0.18" down from top edge
 - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
 - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
 - iv. Remove hinge and de-burr holes in hinge and lid rim.
 - v. Cleco lid to hinge with 5/32 clecos.
 - vi. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations

- d. Record PO of hinge and rivets on attached material tracking list.

4. Install Handle

ADG

- a. Install handle brackets.
 - i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
 - ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
 - iii. Torque AN3 bolts to ??.
- b. Install handle
 - i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
 - ii. Grease two 36275-01 bushings with ???. Insert into bushings of handle assembly.
 - iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
 - iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
 - v. At first end, remove bolt and repeat step iv.
 - vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
 - vii. Torque AN3 bolts to ??.
- c. Check handle
 - i. Operate handle to ensure handle does not bind and springs hold handle in.
 - ii. Snap handle into brackets to ensure handle locks.
- d. Record PO/WO of all parts used in steps above on attached material tracking list.

5. Install lid brace

ADG

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA#)

AK

6. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
 - i. Bolts are tight
 - ii. Rivets are installed correctly
 - iii. Handle operates correctly
 - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

Work Order: 2013-48

Material Tracking Sheet
Bell 206L / 407
Extra Wide Basket Assembly

1 of 2

Date Opened: _____

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
			94510-01	Cargo Basket Assembly		
Step 1				<i>Lid Assembly</i>		
	. 1		69812-01	Basket Lid Assembly		
Step 1.a.	. . 3		49205-14	Bumper	Argus Industries Bumper	
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	. . 1		94527-01	Placard	0.063 Sheet, 6061-T6 Aluminum	
	. . 4		CR3213-4-02	Cherry Rivet		
Step 1.c.	. 1		70405-01	Lid Step Modification		
(option)	. . 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	
	. . A/R		CR3213-4-02	Cherry Rivet		
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 2				<i>Basket Assembly</i>		
Step 2.a.	. 1		94511-01	Basket Body Assembly		
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	13042
	. . 8		NAS1149F0663P	Washer		1304
Step 3				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	72"	13061
	. 8		CR3523-5-02	Cherry Rivet		13048
	. A/R		CR3213-5-02	Cherry Rivet		13048
Step 4	. 1	84255	84255-01	Handle Installation		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	14001/100 8426701
	. . 4		AN3-11A	Bolt		14001
	. . 8		NAS1149F0363P	Washer		13084
	. . 4		MS21044N3	Nut		13048

Work Order: 2013-48Material Tracking Sheet
Bell 206L / 407
Extra Wide Basket Assembly

2 of 2

Date Opened: _____

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	1		84261-01	Handle Assembly		201354
	2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	120 83
	2		36275-01	Bushing	Brass, 5/16" Dia	2013-33
	2		AN3-12A	Bolt		13084
	4		NAS1149F0363P	Washer		13084
	2		MS21044N3	Nut		13048
Step 5				Lid Brace Installation		
	1		36280-01	Brace Assembly		2013-01
	1		AN3-15A	Bolt		13017
	1		AN3-17A	Bolt		13017
	2		AN970-3	Washer		13084
	3		NAS1149F0363P	Washer		13084
	2		MS21044N3	Nut		13048
Step 6				Inspection	None	